

Date: Tuesday, 3/14/2006 10:47:25 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 L/L 1/L3 SCUFF PLATE, AFT RH
Job Number : 26229	
Estimate Number : 12273	
P.O. Number : N/A	Part Number : D206555009
This Issue : 3/14/2006 S.O. No. : N/A	Drawing Number : D206-555 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B C
Previous Run : N/A	Material :
Written By :	Due Date : 3/21/2006 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est C 99.06.29 Returned to Electro Polish DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Type Labels as per PPP D206-555-009

2.0	PG	PURCHASING
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Comment: PURCHASING
 Issue P/O: 00000793
 Email or ship DXF file to vendor
 Laser cut part as per DXF file
 Material release note required

06/03/14

3.0	D206555009F	Scuff Plate Aft RH 206L
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 SCUFF PLATE FLAT

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

06/03/14

5.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06/03/15

P.O-793

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/14/2006 10:47:25 AM
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Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT RH

Job Number: 26229

Part Number: D206555009

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT 8324-9

Finish form on bench forming Jig DT 8325-9

*Complete
here -
16-03-21*

P70

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/03/21

10-03-21 10

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 2181

Electro Polish

206/10/04 10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

206/10/16 10

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

206-10-16

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

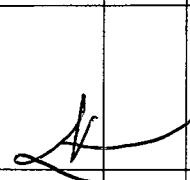
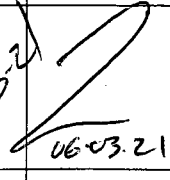



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

60

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-21	6-0	Tooling tabs to be removed at step 6. change made on all 206-555-XXX 2					 06-03-21

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/16/20
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 26229

Part Number: D206555009

Job Number:



Seq. #: Machine Or Operation: Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



N/A
J

Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST/39

Boo 10/18 (10)

Boo 10/18 (10)

14.0

DC

DOCUMENT CONTROL



(10)

Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/20

Job Completion



U 06/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**NORTH AMERICAN
STAINLESS**

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 290000 02

Mail To:
WILKINSON STEEL AND METALS
ATTN: MILL CERTIFICATE SCANNER
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Ship To:
WILKINSON STEEL AND METALS
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Date: 11/22/2005 Page: 1

Steel: 304

Finish: 2B

Corrosion: ASTM A262/02aE, 180Bend-OK

Your Order: P51013PC004

NAS Order: AE 0329272 02

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a, 480/04a, 666/03, ASMESA240/04, SA480/04, SA666/04
QQS766D-A X MG PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
B40627	* 0679E9 A	.0240	48.0000	2,475 SHEET	120.00	2	65
B40628	* 0679E9 A	.0240	48.0000	2,485 SHEET	120.00	3	65

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
79E9	.057	18.152	.369	1.666	.319	.046	8.205	.029	.001	.326

MECHANICAL PROPERTIES

Product ID #	Coil #	l d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Tail Hard	Hard R45T
B40627	0679E9	F T	97.09	48.13	48.98	49.00	46.50
B40628	0679E9	F T	97.09	48.19	48.98	49.00	46.50

QC ENGINEER

ERIC HESS

11/22/2005

60215MD067-1 T 3 INDUSTRIAL (P51013PC004.79E9)

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 290000 02

Mail To:
WILKINSON STEEL AND METALS
ATTN: MILL CERTIFICATE SCANNER
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Ship To:
WILKINSON STEEL AND METALS
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Date: 11/22/2005 Page: 1

Steel: 304

Finish: 2B

Your Order: P51013PC004

NAS Order: AE 0329272 02

Corrosion: ASTM A262/02aE, 180Bend-OK

PRODUCT DESCRIPTION:

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ASTMA240/04a, 480/04a, 666/03, ASMESA240/04, SA480/04, SA666/04
QQS766D-A X MG PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
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B40628	* 0679E9 A	.0240	48.0000	2,485 SHEET	120.00	3	65

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
79E9	.057	18.152	.369	1.666	.319	.046	8.205	.029	.001	.326

MECHANICAL PROPERTIES

Product ID #	Coil #	l d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Tail Hard	Hard R45T
B40627	0679E9	F T	97.09	48.13	48.98	49.00	46.50
B40628	0679E9	F T	97.09	48.19	48.98	49.00	46.50

QC ENGINEER

ERIC HESS

11/22/2005



Certificat de Conformité / Certificate of Compliance

A/TO: Dart Aerospace Ltd.

Date: October 12, 2006

1270 Aberdeen St

No. de certificat
Certification No.

Hawkesbury, Ontario

K6A 1K7

tel.: (613) 632-9577

fax: (613) 632-1053

C108535

bon de T. Job No.	Qt	# de pièce / Part #	Remarques / Remarks
119118		NO. DE COM./P.O.# 2181	ELECTROPOLISH PER ASTM B912 REV.02
	11	D206-555-002 ✓	
	11	D206-555-001 ✓	
	10	D206-555-007 ✓	
	10	D206-555-009 ✓	

Nous certifions que les parties listées ci-dessus ont été faites et inspectées en conformité avec votre bon de commande, vos dessins et spécifications et sont en accord avec les exigences ci-inclus.

We hereby certify that the parts listed above have been processed and inspected in accordance with your purchase order, drawings and specifications, and are correct with regard to the requirements contained therein.

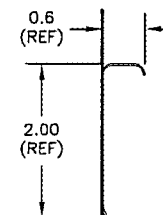
Signé pour et au nom de TQF Technologies Inc.
Signed for and on behalf of TQF Technologies Inc.

RJT

Raj Thakoordeen

Total Quality Finishing

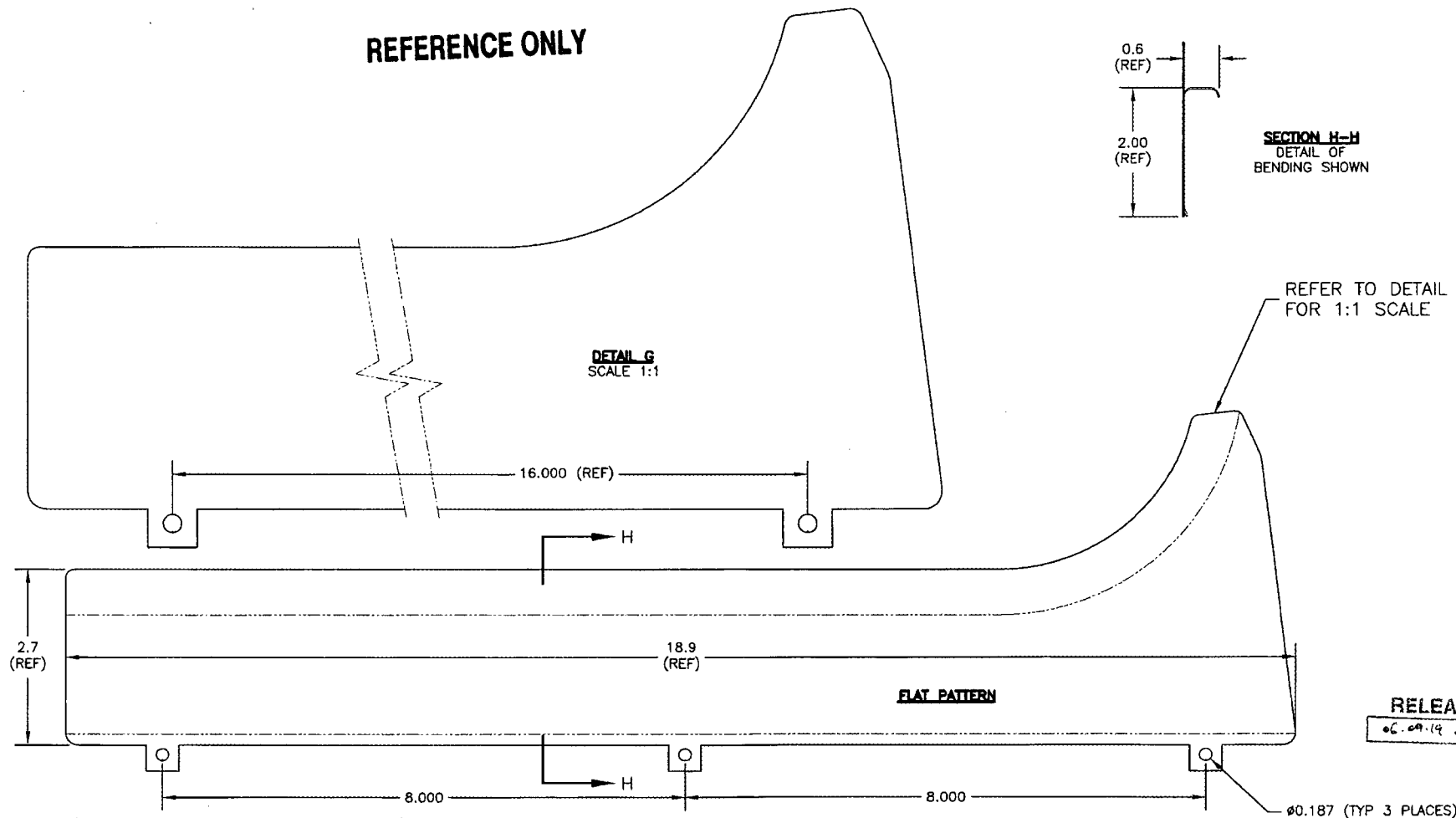
REFERENCE ONLY



SECTION H-H
DETAIL OF
BENDING SHOWN

REFER TO DETAIL G
FOR 1:1 SCALE

DETAIL G
SCALE 1:1



RELEASED

06.09.19

D206-555-008 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED JB	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 2:3	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
2006/10/09

Vendor Address:

T.Q.F. Technologies
6640 Vanden Abeele
St-Laurent, QC H4S 1Y3
Canada
Phone (514) 333-3895
Fax (514) 333-8576

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-TQF001	Oct 04, 2006	N30	Fedex	Oct 18, 2006

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
11.0000	D206555002 B25499	SCUFF PLATE Comments: ELECTRO CHEMICALLY POLISH PER ASTM B912 HIGH SHINE NO SCRATCHES ON SURFACE PLEASE RETURN VIA PUROLATOR COLLECT ACCT: # 7684382	10/18/2006	No	12.600000		138.60
11.0000	D206555001 B27932	SCUFF PLATE Comments: AS ABOVE	10/18/2006	No	12.600000		138.60
10.0000	D206555007 B26228	SCUFF PLATE Comments: AS ABOVE	10/18/2006	No	12.600000		126.00
10.0000	D206555009 B26229	SCUFF PLATE Comments: AS ABOVE	10/18/2006	No	12.600000		126.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

REFERENCE ONLY

Comments:

Tax Summary:

GST 31.75
GSTME 0.00
GSTND 0.00

Less:

included tax

0.00

Subtotal

529.20

Total tax

31.75

Total purchase order in

CAD Dollars

560.95

Entered By: CL CLAVOIE

Approved By: *[Signature]*